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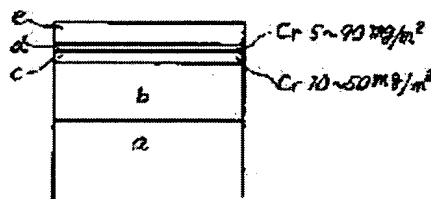
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(54) BLACK PLATED STEEL SHEET EXCELLENT IN ADHESION AND CORROSION RESISTANCE AND ITS PRODUCTION

(57)Abstract:

PURPOSE: To produce a black plated steel sheet excellent in adhesion and corrosion resistance at a high yield by successively coating the surface of a galvanized steel sheet with a black film layer and a chromate film layer of specified coating weight and, furthermore, coating it with a resin film layer.

CONSTITUTION: The surface of a thin steel sheet (a) on which a galvannealing film (b) is applied, is subjected to cathode electrolysis in an aq. soln. contg. NO_3^- , Zn^{2+} , Ni^{2+} and Cr^{3+} and chromate compounds are precipitated as a eutectoid by 10 to 50mg/m² as Cr, and is coated with a black film layer (c). The upper layer of this black film layer (c) is coated with a chromate film layer (d) by 5 to 90mg/m² as Cr, and the upper layer of the chromate film layer (d) is coated with a resin film layer (e) under the conditions in which the inlet side sheet temp. is regulated to be 50 to 80° C and the arrival sheet temp. after baking is regulated to be ?140° C. In this way, the black plated steel sheet having a stable appearance can be obt'd.



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